

Date: Thursday, 5/10/2007 2:26:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 32286		Part Number	: D32931	
Estimate Number	: 11178		Drawing Number	: D3293 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/10/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/6/2007	
Previous Run	: 31516		Qty:	10 Um: Each	
Written By	: <u>ml</u>				
Checked & Approved By	: <u>ml</u> 07.05.10				
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S080	2024-T3 .080 sheet	
		Comment: Qty.: 1.9177 sf(s)/Unit Total : 19.1772 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3293-1 Batch: <u>ml04464</u> <u>ml 07 05 30</u>	(10)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3293 Dwg Rev: <u>A</u> <u>ml 07 05 30</u> Prog Rev: <u>A</u>	(10)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>ml 07 05 30</u>	(10)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>ml 07 05 31</u> (10)	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:26:03 PM
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Drawing Name: DOUBLER

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

SB 07/05/01

(10)

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9 07/06/01

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MR

07/06/01

8.0 POWDER COATING

POWDER COATING



(10X)

M102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

MR 07/06/02

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LC 07/06/04 (10)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST272

2/6/04 (10)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



07/06/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32286
Description: Doubler	Part Number:	D3293-1
Inspection Dwg: D3293 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Mr. M
Date:	07/05/30

Audited by: S

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	JLH

D3293-1 DOUBLER

MAKE PER DRAWING FILE "D3293-A1.DWG"
CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI .005 4.1

POWDER COAT BLA

DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04.07.12 TAK

Technical drawing of a mechanical part with the following dimensions and features:

- Top View:**
 - Central hole diameter: $\phi 0.141$ (TYPICAL 9 PLACES SHOWN)
 - Radius: R0.35 (TYP)
 - Radius: R0.75 (TYP)
 - Width: 13.563 (13 EQUAL SPACES)
 - Radius: R0.128 (TYP 70 PLACES)
 - Radius: R0.107
 - Radius: R0.1010
 - Radius: R0.1594
 - Radius: R0.1630
 - Radius: R0.19259
 - Radius: R0.2015
- Side View:**
 - Width: 11.750
 - Radius: R0.19259
 - Radius: R0.17750
 - Radius: R0.16259
 - Radius: R0.14259
 - Radius: R0.12259
 - Radius: R0.10259
 - Radius: R0.08259
 - Radius: R0.06259
 - Radius: R0.04259
 - Radius: R0.02259
 - Radius: R0.00259
- Bottom View:**
 - Radius: R0.141
 - Radius: R0.128
 - Radius: R0.107
 - Radius: R0.1010
 - Radius: R0.09786
 - Radius: R0.09528
 - Radius: R0.09152
 - Radius: R0.0874
 - Radius: R0.08328
 - Radius: R0.0786
 - Radius: R0.07328
 - Radius: R0.06786
 - Radius: R0.06259
 - Radius: R0.05728
 - Radius: R0.05152
 - Radius: R0.04628
 - Radius: R0.04152
 - Radius: R0.03628
 - Radius: R0.03152
 - Radius: R0.02628
 - Radius: R0.02152
 - Radius: R0.01628
 - Radius: R0.01152
 - Radius: R0.00628
 - Radius: R0.00152

Material and Copy Instructions:

- WORK ORDER NO. 32286
- SHOP COPY
- ENGINEERING
- UNCONTROLLED COPY
- SUBJECT TO AMENDMENT
- WITHOUT NOTICE

DART

DESIGN	<i>IP</i>	DRAWN BY	<i>IP</i>	DART AEROSPACE LTD	
CHECKED	IP	APPROVED	IP	HAWKESBURY, ONTARIO, CANADA	
DATE	04.06.28	DRAWING NO.		SHEET 1 OF 1	
A	04.06.28	D3293		REV. A	
TITLE		DOUBLER		SCALE	
				1:3	

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